Page 1 April-05-13 7:46:26 AM Accept Item ID: D3833-7 \*N900040100\* Setup Start **Revision ID:** Mesh (Lid End) Item Name: \*20\* **Start Qty: 20.00 Start Date:** 4/05/13 **Cust Item ID:** Required Date: 4/19/13 Req'd Qty: 20.00 \*20\* **Customer:** Reference: Run Process Plan: MUS Date: B-04-05 Tooling: Date: Approvals: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Reject Set Up/ Tool # Plan Reject Accept. Insp. Description Work Center ID Qty Number Stamp **Run Hours** Code Qty **Draw Nbr Revision Nbr** D3833 В 100 0.00 FLOW WATER JET \*100\* Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3833 Dwg Rev: 3 Prog Rev: 2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC Quality Control

Memo

0.00

												DQA:	Da	ite:	
NCR: Y	'es	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UP	DATE		QA Closed:	Da	ite:	
						DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Work Orde  Part N  NCR N	 					Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube  Machining noforming Large Fab	Crossto Small Finish Compo	Fab		Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root	Т			[	Descri	ption of work order update		nitial	Act	tion		Sign &		I	·
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verificatio	n_	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	Av.	7				F	<b>AUI</b>	.T CATE	GORY						
Landi	ng G	ear	·	·		General		0/							
		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped at n Strip in ı Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/ nance led	Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	i l'	Torque W	/aves in E	Extrusio	n	Drawing		Out of 0	Calibration						

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

April-05-13 7:46:26 AM

Item ID:

D3833-7

Accept

\*N900040100\*

Setup Start

**Revision ID:** Item Name:

Mesh (Lid End)

**Start Date:** 

Required Date: 4/19/13

4/05/13

**Start Qty: 20.00** Req'd Qty: 20.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: Date: Tooling:

Date:

Run

QC	:	Date:	SPC (Y/N):	D:	ate:		Sto	*NF	₹2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*120 *120*	QC8- Inspect pa	arts - second check	0.00 <b>A</b>	•		П			
QC Quality Control	, Me	emo	0.00 13 4.9						1

130

Identify as per dwg & Stock Location:

0.00

Packaging

Packaging

Memo

0.00

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

Quality Control

Memo

0.00

NCR: Y	es / N	<b>o</b> .			WORK ORDER NON-C	ON	<b>FORI</b>	MANCE / UPDATE				
					•					QA Closed:	Date:	
Work Orde	ır:				DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS	
Part N NCR N	-				Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Crosstub Machining Small Fa noforming Finishin Large Fab Composit	b g	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					iption of work order update	l	itial	Action		Sign &		
Cause	Date	Step	Qty	٠.	or Non-conformance	Chie	ef Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training						· ·						
Unapproved .			1.			ALILT	CATE	CORV		<u> </u>		
Landie	ng Gear				General	AULI	CATE	GORT			<u> </u>	· · · · · · · · · · · · · · · · · · ·
	Bendii Centre Cracks Crushi Cuffs Heat 1 Inspec Ripple	Not Conce ed/Crimped reat tion Strip in s in Bend e Waves in	n Tube Extrusio		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		nstruct Mainte Mislabe Misread Offset Out of 0	ion Incomplete tions Incomplete/Unclear enance eled d		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Turnir	g Sequence	ۆ		Finish		Out of S	Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## Picklist Print

April-05-13 7:46:30 AM

Work Order ID: 99267

\*99267\*

Parent Item:

D3833-7

\*D3833-7\*

Parent Item Name: Mesh (Lid End)

**Start Date:** 4/05/13

Required Date: 4/19/13

**Start Qty: 20.00** 

Required Qty: 20.00

Comments:

IPP REV:A 12.07.27 AS PÉR DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	1,020.634	0.803	-16305	8 \	-	•
*M304FX0	75-16	<u>-</u> *							**	4.496	2 1	13.04	Ø

Expanded Metal Flat SS

<u>Locati</u>	<u>on</u>	Loc Qty	Loc Code	
MAT		772.0496843		
	125113	772.049684		
WA		146.4000637		
	124070	0.00006372		
_	124466	146.4	1	
WA00	7	102.18437		· .
	122534	32.61937		
	123448	15.96		
	124347	53.605		

Page 1

NCR:	⁄es	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UP	DATE			
								T			QA Closed:	Date:	
Work Orde	or.					DISPOSITION		:		AGAINST D	EPARTMENT	/PROCESS	
	٠	a				Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	No.					Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is	]		noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	۱o.		· · · · · · · · · · · · · · · · · · ·	<del> </del>		Work Order Update	ل		Large Fab	Composite		Supplier	
Root					Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data					 						i		
Equip/Tooling					<u> </u>								
Operator	Щ												
Material	Щ								-			·	
Setup													
Other		· i			Į.								,
Process	$\vdash$				ļ ·	•							,
Supplier	Н	1										,	
Training	$\vdash$								*				
Unapproved	1		<u>i</u>	<u> </u>	<u> </u>			LT CATE	SORY				
Landi	ng (	Gear				General	70	ET CATE	<u> </u>				
	_	Bending				Bend	Г	Grain		Γ	Ovalized		Pressure/Forced
	-	Centre No	ot Concei	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	-	Cracks				Broken/Damaged		Inspecti	on incomplete		Part Incorred	ct ·	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/l	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance '		Part Moved		•
		Heat Trea	it			Countersink		Mislabe	led		Positioned V	Vrong	
		Inspection	n Strip in	Tube		Cut Too Short		Misreac	I		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset		· —			
		Torque W	/aves in E	xtrusio	n 🗌	Drawing		Out of C	Calibration				
		Turning S	equence	,		Finish		Out of S	equence	•			

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	99267
Description: Mesh, Lid End	Part Number:	D3833-7
Inspection Dwg: D3833 Rev: B		Page 1 of 1

*. *	FIRST	ARTICLE IN	SPECTION	ON CHE	CKLIST	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.67	+/-0.030	4.67	/			JKM-00
24.75	+/-0.030	24.75	V			
					`	
у .						
		-				
	·					
					·	
Measured by:	1 Mar. M.	Audited by:	<b>2</b>		Preliminary A	pproval:
l	13.04.00	Date:	13-6	9		Date:
,	Change				Davida	ed by A Apprøyed

Micus	uica sy.	$M \setminus M \setminus \dots$		*		ļ				
	Date:	13.04.06	Date:	13-6	9	1		Date:		
		1,50,00		<u> </u>				·		
Rev	Date	Change					Revise	d by ∧	Apprø	y <b>é</b> d
IXCV							KJ	- CAR	CMI	
Α	12.09.26	New Issue					170	<del>171</del>	1-/-/	
	,							7//	/ /	

D3833-3 MESH, LID END D3833-5 MESH, LID END D3833-1 MESH, BASE END FACE

B D3833-7 MESH, LID END

FNCT TOWN 1 UNCONTRACTALL CY SUBJECT TO THE STREET WITHTOTALLICE NO 29262 MUS



В	ADD D3	833-7. REASC	ON: PAR10-50.	MB	12.05.30				
A	NEW IS	SUE		MB	08.09.23				
REV.			DESCRIPTION .	BY	DATE				
DESIG	4		DART AEROS	PACE L	TD				
DRAW		-3	HAWKESBURY, ONTA	ARIO, CANA	DA				
CHECK	ED		DRAWING NO.						
MFG. A	PPR.	M	□D3833		SHEET 1 OF 2				
APPRO	VED	- XM/	TITLE		SCALE				
DE AP	PR.	-W-	MESH, BASKET END M						
DATE	TO THE PARTY OF THE PARTY ASSOCIATED THE								

NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH, 3/4-16F
REF. DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: D3833-1 = 0.30 lbs; D3833-3 = 0.22 lbs; D3833-5 = 0.06 lbs; D3833-7 = 0.30 lbs



